

# Work Order ID 70735

Tuesday, June 14, 2011 9:22:55 AM



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Item ID: D2892-1

Accept



Setup Start



Revision ID: U/R

Item Name: Support

Stop



Start Date: 6/14/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 30.00



Customer:

Reference: Rework

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2892

Rev A U/R *OK* *11.06.13*

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

PULL FROM STOCK:  
14 X D2892-1 B42785 -  
14 X D2892-1 B68808 -  
2 X D2892-1 B70115 -

STRIP PAINT COMPLETELY PER U/R FORM 11/06/13

*21 11-06-15*

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*11 06 15*

W/O: 70735		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.06.16	130	Remove all finish from D2892-1 supports REF D.S. EMAIL	AT	11-06-15	30	P 11.06.16 DSI 042	S W104/20

Part No: D2892-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70735**

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Tuesday, June 14, 2011 9:22:55 AM

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Stop



Item Name: Support

Start Date: 6/14/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *X tube* 0.00

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

*85 11-06-15*

160

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*11/6/16**ME 11-06-16*

# Picklist Print

Tuesday, June 14, 2011 9:22:52 AM

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Work Order ID: 70735



Parent Item: D2892-1



Parent Item Name: Support

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 30.00

Required Qty: 30.00

**Comments:**

IPP C 02.11.26 Added P/O KJ

IPP D 08.03.19 Re-format EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2892-1

Manufactured

No

Each

0.0000

30



Support

70115 x 2  
42785 x 14  
68808 x 14



25 11-06-15

# Under Review Notification

Raised By: Chris Provencal

Date: 11.06.13

Product #: 667, 676, and 664

Product Name: crosstubes

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2891-1	Support				Y	Y	N	Y	Y	Y	Y		
D2892-1	Support				Y	Y	N	Y	Y	Y	Y		
D2893-1	Support				Y	Y	N	Y	Y	Y	Y		
D2940-1	Support				Y	Y	N	Y	Y	Y	Y		
D212-664-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D412-664-145	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-147	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-241	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-247	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-143	Crosstube				Y	Y	N	Y	Y	Y	Y		
D407-667-145	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-147	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-241	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-243	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-247	Crosstube				Y	Y	N	Y	Y	Y	Y		
D058-676-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D058-667-241	Crosstube				Y	Y	N	Y	Y	Y	Y		

## Description of issue:

- Process to bond supports onto crosstube is changing
- Finish on supports and xtube will change
- Get new process instructions from ENG prior to making more xtubes
- Modified crosstubes will need a new CHG number

Item ID	Item Name	Lot Qty	Lot Nbr
D2891-1	2.25 Support	9	53773
D2891-1	2.25 Support	20	68522
D2892-1	Support	14	42785
D2892-1	Support	14	68808
D2892-1	Support	2	70115
D2893-1	2.75 Support	15	69713
D2893-1	2.75 Support	5	69713
D2893-1	2.75 Support	1	68799
D2894-1	2.750 Support	4	66702
D2894-1	2.750 Support	4	43881
D2896-1	Support	11	67742
D2940-1	Support	20	68373
D2940-1	Support	1	60271

## Chris Provencal

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**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** Wednesday, June 15, 2011 3:05 PM  
**To:** 'Chris Provencal'  
**Cc:** 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'; 'Linda Lacelle'  
**Subject:** RE: Procedure for installing supports.

Hi Chris,

I agree with your procedure outlined below. It is our preference to leave the paint on the crosstube if we can for added corrosion protection (and for ease of manufacture). If Dan's final testing shows there is a big difference between a painted/unpainted crosstube, then we will switch to alodine only on the crosstube.

David

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**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Wednesday, June 15, 2011 11:24 AM  
**To:** 'David Shepherd'  
**Cc:** 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'  
**Subject:** RE: Procedure for installing supports.

David,

Can I confirm that this is the agreed procedure for all newly manufactured tubes with off-center supports:

- Scuff paint under support, clean with MEK
- Completely remove any finish on support (if present), scuff bottom surface of support, clean with MEK
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Let cure for 72 hours after installation, recheck torque.

Chris

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**From:** David Shepherd [mailto:dshepherd@dartaero.com]  
**Sent:** Tuesday, June 14, 2011 10:59 AM  
**To:** 'Chris Provencal'  
**Cc:** 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'  
**Subject:** RE: Procedure for installing supports.

Made a couple of small changes.

- Remove finish on xtube in area of support down to alodine finish.
- Touch up alodine on xtube in affected area
- Completely remove any finish on support, scuff bottom surface of support
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Touch up paint finish as req'd per QSI 005
- Let cure for 72 hours after installation, recheck torque.